

Work Order ID 164254

Monday, July 17, 2017 7:40:51 AM

164254

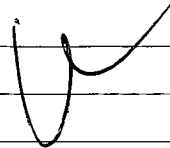
Page 1

Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad

Start Date: 6/28/2017 Start Qty: 30.00 ***30***
Required Date: 7/11/2017 Req'd Qty: 30.00 ***30***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:  Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3537	E

110 0.00

110

FLOW WATER JET

Waterjet

Memo

1.11

FLOW CNC Waterjet

1-Cut D3537-1 as per Dwg D3537

Dwg Rev: EProg Rev: E

2-Deburr if necessary

07/17/17

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.30

Quality Control

07/17/17

Page 2

~~JUL 18 2017~~

Work Order ID 164254***164254***

Page 3

Monday, July 17, 2017 7:40:51 AM

Item ID: D3537-1 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 6/28/2017 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 7/11/2017 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* autoweld 1 Automated Welding 1	Weld per dwg & QSI004 4.5 Large Fab Memo ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: <u>1137414</u>	0.00 3.00				<u>30</u>	<u>Q.L</u>	<u>17-07-25</u>	
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.02 0.30				<u>30</u>			DAS 38 9286 JUL 26 2017
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.60				<u>30</u>			DAS 38 JUL 26 2017

Work Order ID 164254

Monday, July 17, 2017 7:40:51 AM

164254

Page 4

Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 6/28/2017 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 7/11/2017 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: _____	0.00							
210									
Packaging		0.30							
Packaging	Memo LOCATION : FP001								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	3.00							
Quality Control									

30 JUL 27 2017 DAS
6
9-89

1.7/7/31 9

DAS
21
9-89 JUL 27 2017

Picklist Print

Monday, July 17, 2017 7:40:49 AM

Page 1

Work Order ID: 164254

164254

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 6/28/2017

Required Date: 7/11/2017

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 07-02-14 JLM
15.10.16 added automated welding DD verf:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	22.9920	0.106	3.347368			

M304S16GA

304/316 Sheet .063

**

06/17/07/17

Location

Loc Qty

Loc Code

MAT010

22.992

m136896

0.3

m137110

0.132

m137175

1.1

m137341

2.62

m137400

12.1

m137844

6.74

3.2

5

DART AEROSPACE LTD		Work Order:	164254
Description: Wearpad		Part Number:	D3537-1
Inspection Dwg: D3537 Rev: E			Page 1 of 1

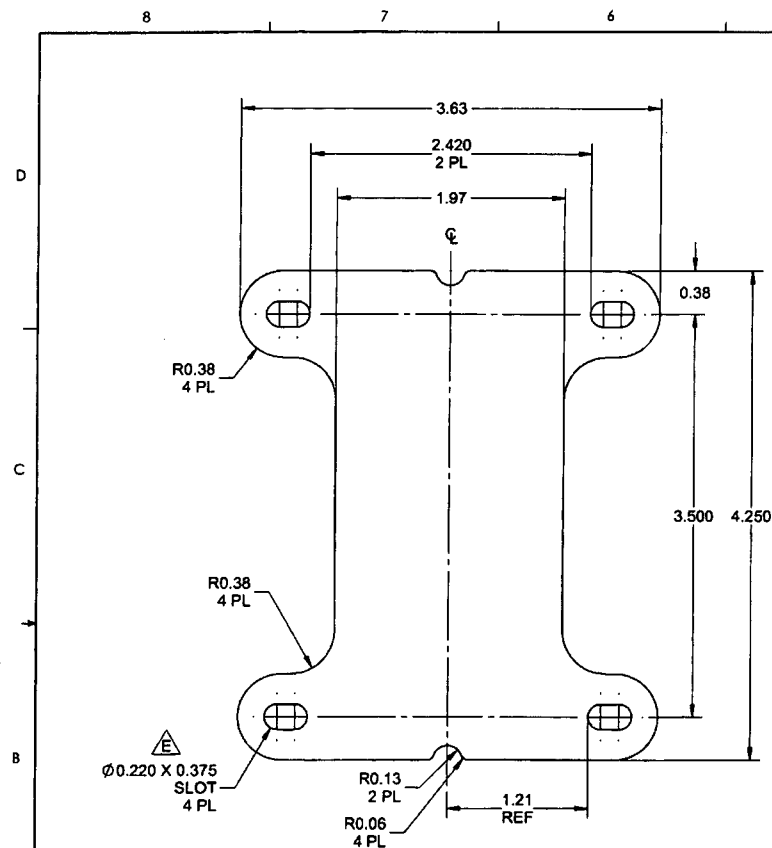
INSPECTION SHEET

[illegible]

Measured by:	<i>de</i>	Checked by:	38	QC Inspector:	
Date:	17/07/17	Date:	JUL 17 2017	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

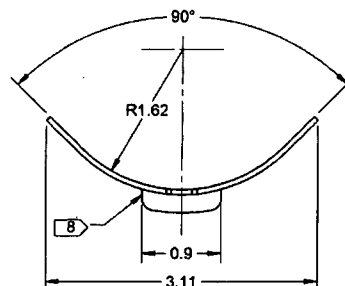
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	
D	15.02.26	Dwg Rev updated	KJ	
E	15.09.09	Dimensions revised per Dwg Rev. D	KJ	
F	16.02.19	Dimensions revised per Dwg Rev. E	KJ	
G	16.08.29	Dimension 0.375 was 0.0750	KJ	



D3537-1F WEARPAD
(FLAT PATTERN)

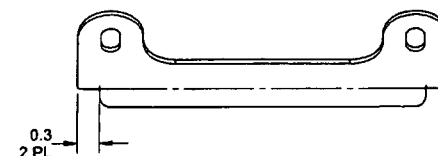
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.42 lbs
- 8) BUILDUP HARD SURFACING 0.17 - 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 - 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)



D3537-1 WEARPAD
MAKE FROM D3537-1F

also 161254

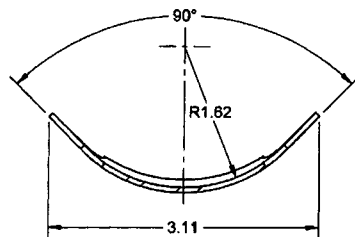


RELEASED
2015-12-07
EW 15-651

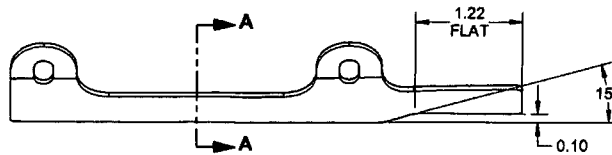
E	-5 DELETED PART IS OBSOLETE. RE-FORMAT. NOTE 8 RE-WRITTEN FOR ROBOTIC WELDING. SHEETS 1 & 2 SLOT DIMENSION UPDATED.		AJS	15.09.28
D	RE-FORMAT DRAWING, ADD -9/-11 WEARPADS		DB	14.10.16
C	WIDEN TAB TO 0.380, WEL PATTERN		CB	07.04.13
B	ADD AMS5510 AND AMS 5524		CB	07.03.20
A	NEW ISSUE		CB	06.11.06
REV.			DESCRIPTION	BY DATE
DESIGN		CB	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN		AJS		
CHECKED		AP	DRAWING NO.	REV. E
MFG. APPR.		JLM	D3537	SHEET 1 OF 5
APPROVED		WM	TITLE	SCALE
DE APPR.		DS	WEARPAD	NTS
DATE		15.09.28	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

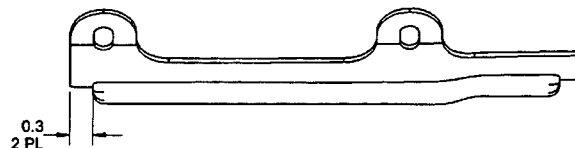
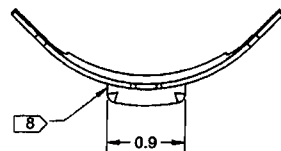
8 7 6 5 4 3 2 1



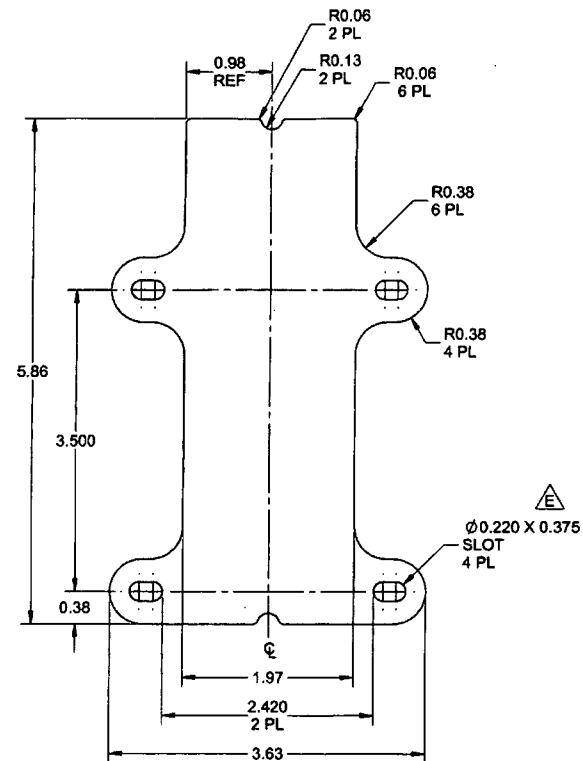
SECTION A-A



**D3537-3 WEARPAD
(BENDING DETAIL)
(MAKE FROM D3537-3F)**



**D3537-3 WEARPAD
(WELDMENT)**



**D3537-3F WEARPAD
(FLAT PATTERN)**

NOTES:

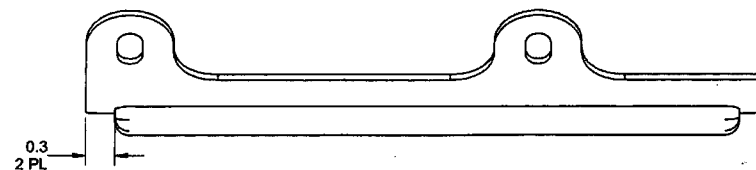
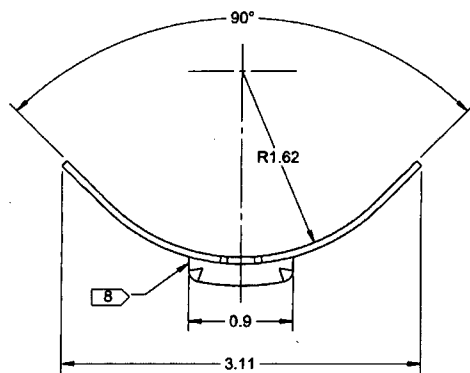
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.50 lbs
- 8) BUILDUP HARD SURFACING 0.17 - 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 - 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

RELEASED
2015-12-07

APPROVED

DESIGN	CB	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	JLM	D3537	SHEET 2 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
DATE	15.09.28	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D3537-7 WEARPAD
(MAKE FROM D3537-3F)

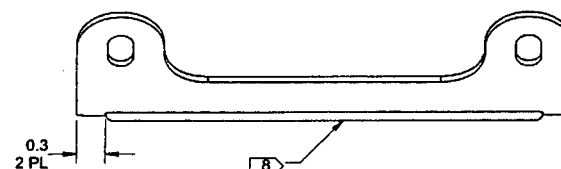
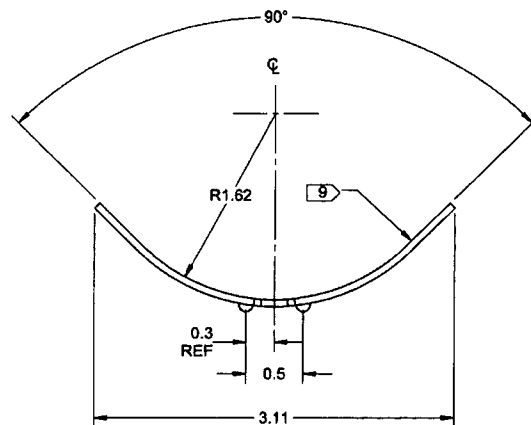
NOTES:

- 1) MATERIAL: MAKE FROM -3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.50 lbs
- 8) BUILDUP HARD SURFACING 0.17 - 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.19 - 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

RELEASED
2015-12-07

APPROVED

DESIGN	CB	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	JLM	D3537	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
DATE	15.09.28	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3537-9 WEARPAD
(MAKE FROM D3537-1P)

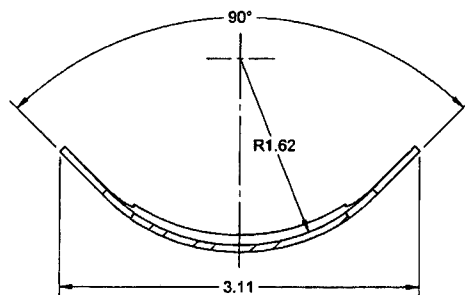
NOTES:

- 1) MATERIAL : MAKE FROM -1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.19 lbs
- 8) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY HARD SURFACING WELD BEAD 0.08 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

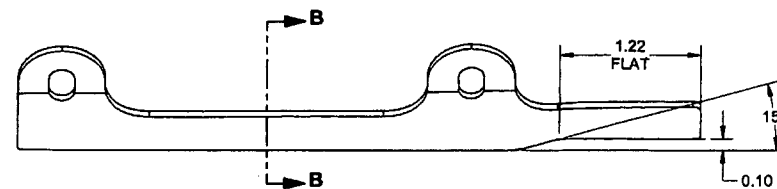
RELEASED
2015-12-07

APPROVED

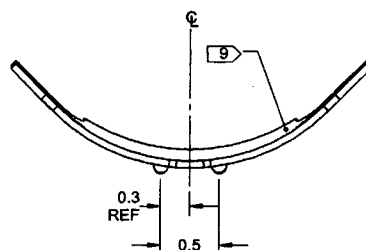
DESIGN	CB	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	JLM	D3537	SHEET 4 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
DATE	15.09.28	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



SECTION B-B



D3537-11 WEARPAD
(BENDING DETAIL)
(MAKE FROM D3537-3F)



D3537-11 WEARPAD
(WELDMENT)

NOTES:

- 1) MATERIAL: MAKE FROM -3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.25 lbs
- 8) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

RELEASED
2015-12-07

APPROVED

DESIGN	CB	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	JLM	D3537	SHEET 5 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
DATE	15.09.28	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	